

June 10

Work Order ID 59137



Wednesday, May 26, 2010 1:55:18 PM

Page 1

Item ID: D4039-1

Accept



Setup Start



Revision ID:

Item Name: Fwd Bracket

Stop



Start Date: 5/26/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

05-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4039

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4039-1_BLANK

B 10-5-26

(2)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA880 AND DWG

FOLIO REV: *A-1*

DWG REV: *A*

DEBURR

cut 10/06/02

2 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4039-1

Accept

Revision ID:

Item Name: Fwd Bracket

Start Date: 5/26/2010 Start Qty: 2.00

Required Date: 6/4/2010 Req'd Qty: 2.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>10/06/07</i>		<i>2</i>	<i>0</i>		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>10/06/07</i>		<i>2</i>	<i>0</i>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		<i>7m-l 10/06/07</i>		<i>(2x)</i>			

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Page 3

Item ID: D4039-1

Accept

Revision ID:

Item Name: Fwd Bracket

Start Date: 5/26/2010 Start Qty: 2.00

Required Date: 6/4/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

QC3- Inspect Part Finish

0.00

160



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

② BL 10-6-8

E 50/06/09 ②

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 59137
Description: FWD Bracket		Part Number: D4039-1
Inspection Dwg: D4039 Rev: A		Page 1 of 1

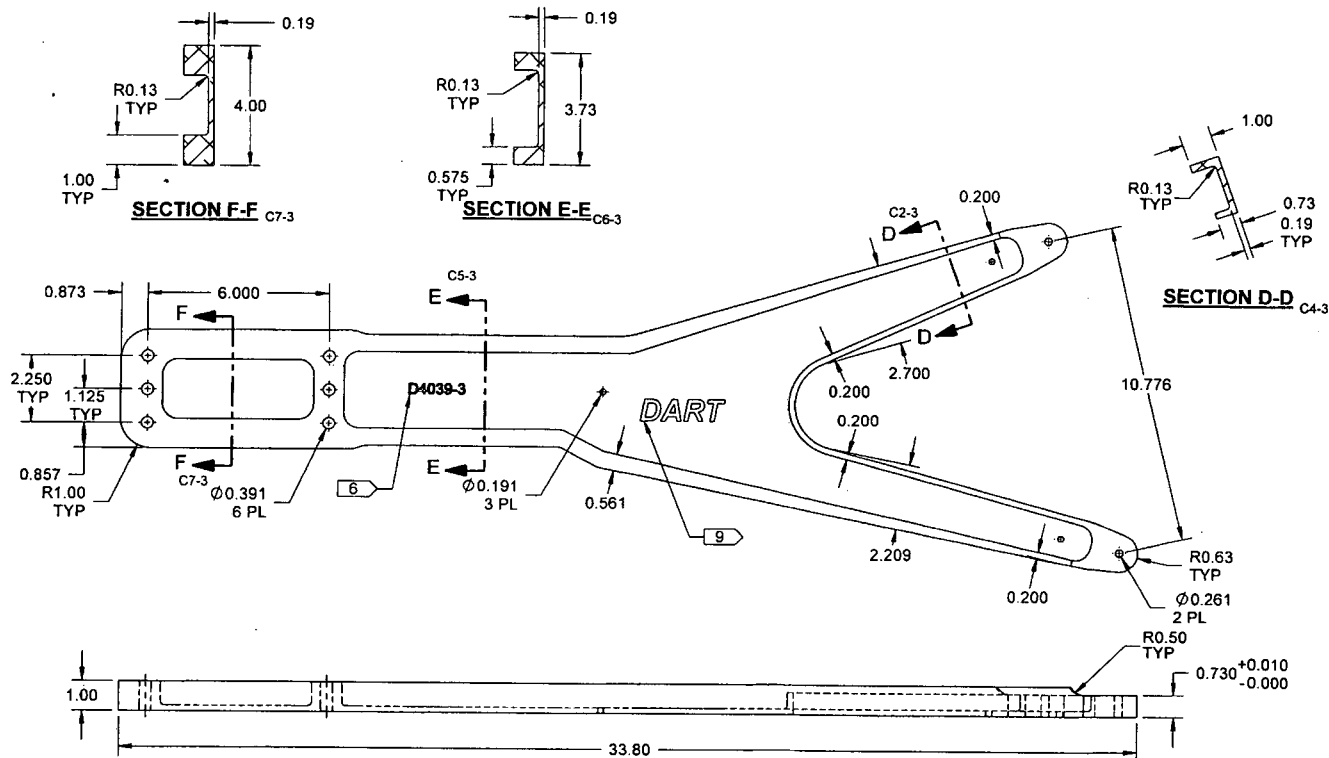
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.19	$\pm .030$.193	—			
4.00	$\pm .030$	4.00	—			
1.00	$\pm .030$	1.001	—			TYP.
R.13	$\pm .030$	R.130	—			TYP.
3.73	$\pm .030$	3.733	—			
.875	$\pm .010$.876	—			
2.250	$\pm .010$	2.249	—			
.875	$\pm .010$.875	—			
6.000	$\pm .010$	5.948	—			
Ø.391	$\pm .006$	Ø.395	—			
.200	$\pm .010$.200	—			
Ø.261	$\pm .005$	Ø.264	—			
Ø.203	$\pm .005$	Ø.204	—			
1.00	$\pm .030$	1.021	—			
34.40	$\pm .030$	34.400	—			
R.50	$\pm .030$	R.500	—			
.730	$\pm .010$.738	—			

Measured by: <i>amf</i>	Audited by: <i>MW</i>	Prototype Approval:	N/A
Date: 10/06/02	Date: 10/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4039-3 FWD BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3 REVA.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59132

RELEASED
2010-04-14
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4039	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE BRACKET	SCALE
DE APPR.			NTS
DATE	09.12.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

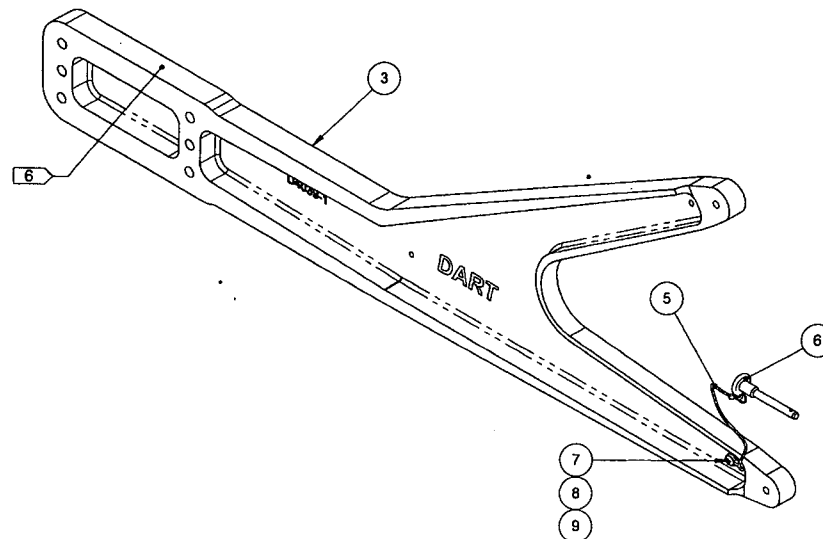
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

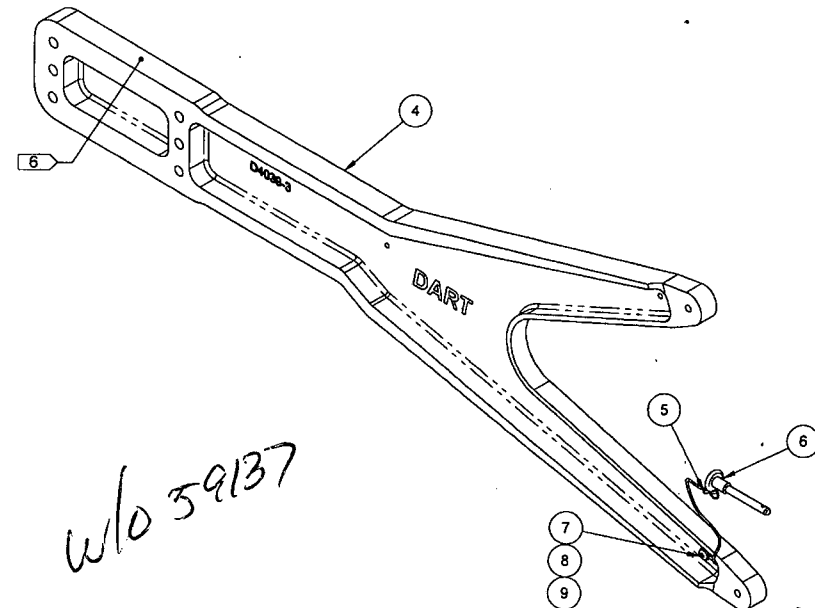
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

RELEASED
2010-04-14

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4039-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A

A	NEW ISSUE	BY	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.12.14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4039	REV. A
TITLE BRACKET	SCALE NTS
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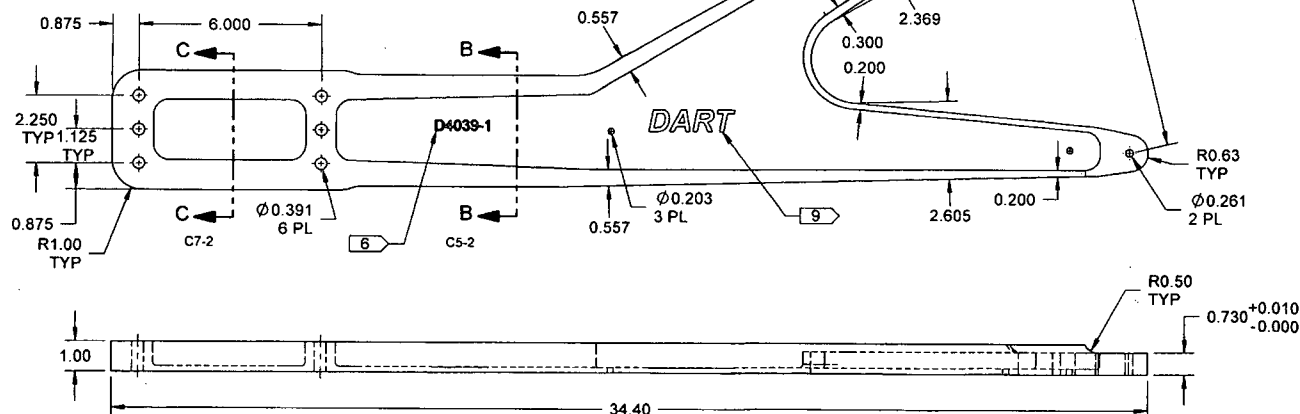
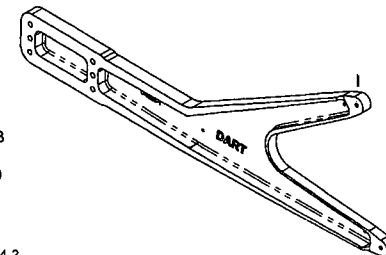
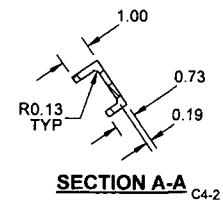
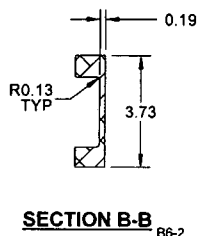
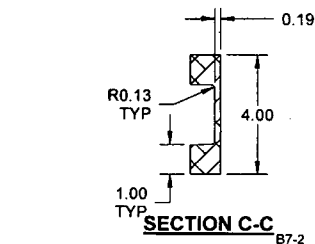
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D4039-1 FWD BRACKET

- NOTES:**
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REF DART SPEC M6061T6S1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
 - 7) WEIGHT: 6.64 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4039-1_REVA.SLDPRT"
 - 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4039 REV. A
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE BRACKET SCALE
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W6 59137

RELEASED
R 2010-04-16
NW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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